DEPARTMENT OF TRANSPORTATION
DIVISION OF ENGINEERING SERVICES
Office of Structural Materials
Quality Assurance and Source Inspection

Bay Area Branch
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Contract #: 04-0120F4
Cty: SF/ALA Rte: 80 PM: 13.2/13.9
File #: 69.28

WELDING INSPECTION REPORT

Resident Engineer: Pursell, Gary
Address: 333 Burma Road
City: Oakland, CA 94607

Report No: WIR-014732
Date Inspected: 03-Jun-2010

Project Name: SAS Superstructure
Prime Contractor: American Bridge/Fluor Enterprises, a JV
Contractor: Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island

OSM Arrival Time: 700
OSM Departure Time: 1900
Location: Shanghai,China

CWI Name:	Mr.An Qing Xiang/Qiu wen	**CWI Present:**	☑ Yes ☐ No
Inspected CWI report:	☐ Yes ☑ No ☐ N/A	**Rod Oven in Use:**	☑ Yes ☐ No ☐ N/A
Electrode to specification:	☑ Yes ☐ No ☐ N/A	**Weld Procedures Followed:**	☑ Yes ☐ No ☐ N/A
Qualified Welders:	☑ Yes ☐ No ☐ N/A	**Verified Joint Fit-up:**	☑ Yes ☐ No ☐ N/A
Approved Drawings:	☑ Yes ☐ No ☐ N/A	**Approved WPS:**	☑ Yes ☐ No ☐ N/A
		Delayed / Cancelled:	☐ Yes ☑ No ☐ N/A
Bridge No:	34-0006	**Component:**	Tower

Summary of Items Observed:

On this date Caltrans OSM Quality Assurance (QA) Inspector, Nagalingam Pandaram Pillai was present during the times noted above for observations relative to the work being performed.

Magnetic Particle Testing:-
BAY #11:-
This QA inspector performed Magnetic Particle Testing (MT) of approximately 15% of the area previously tested and accepted by ZPMC Quality Control Personnel. This QA Inspector generated an MT report for this date. The member is identified as Tower Strut Plate. The weld designations reviewed are as follows:-

ND1-A468-33M-1
ND1-A468-28M-1
ND1-A468-23M-1

BAY #10:-
This QA inspector performed Magnetic Particle Testing (MT) of approximately 15% of the area previously tested and accepted by ZPMC Quality Control Personnel. This QA Inspector generated an MT report for this date. The member is identified as Tower Skirt Plate. The weld designations reviewed are as follows:-

SSD1-SA79B/B-1-3,4,5
SSD1-SA79B/B-2-3,4,5
NSD1-SA158B/B-1,2,10,16,17

SSD1-SA623B/B-1,8,16,21
SSD1-SA623A/B-6

Trail Assembly Area:-
This QA inspector performed Magnetic Particle Testing (MT) of approximately 15% of the area previously tested and accepted by ZPMC Quality Control Personnel. This QA Inspector generated an MT report for this date. The member is identified as Tower Cross Bracing Gusset Plate. The weld designations reviewed are as follows:-
WD1-GUSA3-3-53M-S-3A/B
WD1-GUSA3-3-53M-S-4A/B
WD1-GUSA3-3-53M-N-3A/B
WD1-GUSA3-3-53M-N-4A/B

Ultrasonic Testing:-
Trail Assembly Area:-
This QA inspector performed Ultrasonic Testing (UT) of approximately 10% of the previously tested and accepted by ZPMC Quality Control Personnel. This QA Inspector generated an UT report for this date. The member is identified as Tower Cross Bracing Gusset Plate. The weld designations reviewed are as follows:

WD1-GUSA3-3-53M-S-3A/B
WD1-GUSA3-3-53M-S-4A/B
WD1-GUSA3-3-53M-N-3A/B
WD1-GUSA3-3-53M-N-4A/B

IN PROCESS INSPECTION:-
Trail Assembly Area:-

This QA inspector observed the following work in progress:
SMAW welding of weld joint no: WD1-GUSA3-3-65M-W-4A located on Cross Bracing Gusset Plate. Welder is identified as 040690. ZPMC CWI is identified as Mr.Qiu wen. Welding was been performed against Temporary Weld Repair Report. The welding variables recorded by QC appeared to comply with the WPS-345-SMAW-1G(1F)-FCM-Repair.

This QA inspector observed the following work in progress:
SMAW welding of weld joint no: WD1-GUSA3-3-65M-N-3A located on Cross Bracing Gusset Plate. Welder is identified as 040280. ZPMC CWI is identified as Mr. Qiu wen. Welding was been performed against Temporary Weld Repair Report. The welding variables recorded by QC appeared to comply with the WPS-345-SMAW-1G(1F)-FCM-Repair.

This QA inspector observed the following work in progress:
SMAW welding of weld joint no: WD1-GUSA3-3-65M-S-3B located on Cross Bracing Gusset Plate. Welder is identified as 040582. ZPMC CWI is identified as Mr. Qiu wen. Welding was been performed against Temporary Weld Repair Report. The welding variables recorded by QC appeared to comply with the WPS-345-SMAW-4G(4F)-FCM-Repair.

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This QA inspector observed the following work in progress:
SMAW welding of weld joint no: WD1-GUSA3-3-65M-E-4B located on Cross Bracing Gusset Plate. Welder is identified as 040610. ZPMC CWI is identified as Mr. Qiu wen. Welding was been performed against Temporary Weld Repair Report. The welding variables recorded by QC appeared to comply with the WPS-345-SMAW-4G(4F)-FCM-Repair.

Bay#10:-

This QA inspector observed the following work in progress:
SMAW welding of weld joint no: SSD1-SPSA5-16-2A located on Lift 5 Interior Splice Plate. Welder is identified as 050289.ZPMC QC is identified as Mr. Yu Zhi Lai. The welding variables recorded by QC appeared to comply with the WPS-B-T-3211-TC-U5b-1.

This QA inspector observed the following work in progress:
SMAW welding of weld joint no: SSD1-SPSA5-19-1B located on Lift 5 Interior Splice Plate. Welder is identified as 052930.ZPMC QC is identified as Mr. Yu Zhi Lai. The welding variables recorded by QC appeared to comply with the WPS-B-T-3211-TC-U5b-1.

Unless otherwise noted, all work observed on this date appeared to generally comply with the applicable contract documents.

Summary of Conversations:
No Relevant Conversation.
Comments
This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Skyler Guest - 15000422360, who represents the Office of Structural Materials for your project.

Inspected By: Pillai,Pandaram Quality Assurance Inspector

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Reviewed By: Clifford,William QA Reviewer